

| 公制细螺纹 | | | | 公制标准螺纹 | | | |
|-----------|------|---------|--------|----------------------|-------|-------------|-------|
| 规格 | 标准径 | 2 级螺纹内径 | | 规格 | 标准径 | 1 级-2 级螺纹内径 | |
| | | 上限 | 下限 | | | 上限 | 下限 |
| M1*0.25 | 0.75 | 0.785 | 0.729 | M1*0.20 | 0.8 | 0.821 | 0.783 |
| M1.1*0.25 | 0.85 | 0.885 | 0.829 | M1.1*0.20 | 0.9 | 0.921 | 0.883 |
| M1.2*0.25 | 0.95 | 0.985 | 0.929 | M1.2*0.20 | 1 | 1.021 | 0.983 |
| M1.4*0.3 | 1.1 | 1.142 | 1.075 | M1.4*0.20 | 1.2 | 1.221 | 1.183 |
| M1.6*0.35 | 1.25 | 1.321 | 1.221 | M1.6*0.20 | 1.4 | 1.421 | 1.383 |
| M1.7*0.35 | 1.35 | 1.421 | 1.321 | *M1.7*0.20 | 1.45 | 1.5 | 1.46 |
| M1.8*0.35 | 1.45 | 1.521 | 1.421 | M1.8*0.20 | 1.6 | 1.621 | 1.583 |
| M2*0.4 | 1.6 | 1.679 | 1.576 | M2*0.25 | 1.75 | 1.785 | 1.729 |
| M2.2*0.45 | 1.75 | 1.838 | 1.713 | M2.2*0.25 | 1.95 | 1.985 | 1.929 |
| M2.3*0.4 | 1.9 | 1.979 | 1.867 | *M2.3*0.25 | 2.05 | 2.016 | 2.001 |
| M2.5*0.45 | 2.1 | 2.138 | 2.013 | M2.5*0.35 | 2.121 | 2.221 | 2.121 |
| M2.6*0.45 | 2.2 | 2.238 | 2.113 | *M2.6*0.35 | 2.2 | 2.246 | 2.186 |
| M3*0.5 | 2.5 | 2.599 | 2.459 | M3*0.35 | 2.7 | 2.721 | 2.621 |
| *M3*0.6 | 2.4 | 2.44 | 2.28 | M3.5*0.35 | 3.2 | 3.221 | 3.121 |
| M3.5*0.6 | 2.9 | 3.01 | 2.85 | M4*0.50 | 3.5 | 3.599 | 3.459 |
| M4*0.7 | 3.3 | 3.422 | 3.242 | M4.5*0.50 | 4 | 4.099 | 3.959 |
| *M4*0.75 | 3.25 | 3.326 | 3.106 | M5*0.50 | 4.5 | 4.599 | 4.459 |
| M4.5*0.75 | 3.8 | 3.878 | 3.688 | M5.5*0.50 | 5 | 5.099 | 4.959 |
| M5*0.8 | 4.2 | 4.334 | 4.134 | M6*0.75 | 5.3 | 5.378 | 5.188 |
| *M5*0.9 | 4.1 | 4.17 | 3.93 | *M6*0.5 | 5.5 | 5.55 | 5.4 |
| M6*1 | 5 | 5.153 | 4.917 | M7*0.75 | 6.3 | 6.378 | 6.188 |
| M7*1 | 6 | 6.153 | 5.917 | *M7*0.50 | 6.5 | 6.55 | 6.4 |
| M8*1.25 | 6.8 | 6.912 | 6.647 | M8*1.0 | 7 | 7.153 | 6.917 |
| M9*1.25 | 7.8 | 7.912 | 7.647 | M8*0.75 | 7.3 | 7.378 | 7.188 |
| M10*1.5 | 8.5 | 8.676 | 8.376 | *M8*0.50 | 7.5 | 7.52 | 7.4 |
| M11*1.5 | 9.5 | 9.676 | 9.376 | M9*1.0 | 8 | 8.153 | 7.917 |
| M12*1.75 | 10.3 | 10.441 | 10.106 | M9*0.75 | 8.3 | 8.378 | 8.188 |
| M14*2 | 12 | 12.21 | 11.835 | M10*1.25 | 8.8 | 8.912 | 8.647 |
| M16*2 | 14 | 14.21 | 13.835 | | | | |
| M18*2.5 | 15.5 | 15.744 | 15.249 | | | | |
| M20*2.5 | 17.5 | 17.744 | 17.249 | | | | |
| M22*2.5 | 19.5 | 19.744 | 19.249 | | | | |
| M24*3 | 21 | 21.252 | 20.752 | | | | |
| M27*3 | 24 | 24.252 | 23.752 | | | | |
| M30*3.5 | 26.5 | 26.771 | 26.211 | | | | |
| M33*3.5 | 29.5 | 29.771 | 29.211 | | | | |
| M36*4 | 32 | 32.27 | 31.67 | | | | |
| M39*4 | 35 | 35.27 | 34.67 | | | | |
| M42*4.5 | 37.5 | 37.779 | 37.129 | | | | |
| M45*4.5 | 40.5 | 40.779 | 40.129 | | | | |
| M48*5 | 43 | 43.279 | 42.587 | | | | |
| | | | | 附* 号螺纹自学 968 年 3 月删除 | | | |

公制细螺纹

| 规格 | 标准径 | 2 级螺纹内径 | | 规格 | 标准径 | 2 级螺纹内径 | |
|-----------|------|---------|--------|----------------------|------|---------|--------|
| | | 上限 | 下限 | | | 上限 | 下限 |
| M10*1 | 9 | 9.153 | 8.917 | M32*1.50 | 30.5 | 30.676 | 30.376 |
| M10*0.75 | 9.3 | 9.378 | 9.188 | M33*3 | 30 | 30.252 | 29.752 |
| *M10*0.5 | 9.5 | 9.52 | 9.4 | M33*2 | 31 | 31.21 | 30.835 |
| M11*1 | 10 | 10.153 | 9.917 | M33*1.50 | 31.5 | 31.676 | 31.376 |
| M11*0.75 | 10.3 | 10.378 | 10.188 | M35*1.50 | 33.5 | 33.676 | 33.376 |
| M12*1.5 | 10.5 | 10.676 | 10.376 | M36*3.0 | 33 | 33.252 | 32.752 |
| M12*1.25 | 10.8 | 10.912 | 10.647 | M36*2.0 | 34 | 34.21 | 33.835 |
| M12*1 | 11 | 11.153 | 10.917 | M36*1.50 | 34.5 | 34.676 | 34.376 |
| *M12*0.5 | 11.5 | 11.52 | 11.4 | M38*1.50 | 36.5 | 36.676 | 36.376 |
| M14*1.5 | 12.5 | 12.676 | 12.376 | M39*3 | 36 | 36.252 | 35.752 |
| M14*1.0 | 13 | 13.153 | 12.917 | M39*2 | 37 | 37.21 | 36.835 |
| M15*1.5 | 13.5 | 13.676 | 13.376 | M39*1.50 | 37.5 | 37.676 | 37.376 |
| M15*1.0 | 14 | 14.153 | 13.917 | M40*3 | 37 | 37.252 | 36.752 |
| M16*1.50 | 14.5 | 14.676 | 13.917 | M40*2 | 38 | 38.21 | 37.835 |
| M16*1.0 | 15 | 15.153 | 14.376 | M40*1.50 | 38.5 | 38.676 | 38.376 |
| M17*1.50 | 15.5 | 15.676 | 14.917 | M42*4 | 38 | 38.27 | 37.67 |
| M17*1.0 | 16 | 16.153 | 15.376 | M42*3 | 39 | 39.252 | 38.752 |
| M18*2.0 | 16 | 16.21 | 15.835 | M42*2 | 40 | 40.21 | 39.835 |
| M18*1.50 | 16.5 | 16.676 | 16.376 | M42*1.50 | 40.5 | 40.676 | 40.376 |
| M18*1.0 | 17 | 17.153 | 16.917 | M45*4 | 41 | 41.27 | 40.67 |
| M20*2.0 | 18 | 18.21 | 17.835 | M45*3 | 42 | 42.252 | 41.752 |
| M20*1.50 | 18.5 | 18.676 | 18.376 | M45*2 | 43 | 43.21 | 42.835 |
| M20*1.0 | 19 | 19.153 | 18.917 | M45*1.50 | 43.5 | 43.676 | 43.376 |
| M22*2 | 20 | 20.21 | 19.835 | M48*4 | 44 | 44.27 | 43.67 |
| M22*1.50 | 20.5 | 20.676 | 20.376 | M48*3 | 45 | 45.252 | 44.752 |
| M22*1.0 | 21 | 21.153 | 20.917 | M48*2 | 46 | 46.21 | 45.835 |
| M24*2.0 | 22 | 22.21 | 21.835 | M48*1.50 | 46.5 | 46.676 | 46.376 |
| M 24*1.50 | 22.5 | 22.676 | 22.376 | M50*3 | 47 | 47.252 | 46.752 |
| M24*1.0 | 23 | 23.153 | 22.917 | M50*2 | 48 | 48.21 | 47.835 |
| M25*2.0 | 23 | 23.21 | 22.835 | M50*1.50 | 48.5 | 48.676 | 48.376 |
| M25*1.50 | 23.5 | 23.676 | 23.376 | | | | |
| M25*1.0 | 24 | 24.153 | 23.917 | | | | |
| M26*1.50 | 24.5 | 24.676 | 24.376 | | | | |
| M27*2.0 | 25 | 25.21 | 24.835 | | | | |
| M27*1.50 | 25.5 | 25.676 | 25.376 | | | | |
| M27*1.0 | 26 | 26.153 | 25.917 | | | | |
| M28*2.0 | 26 | 26.21 | 25.835 | | | | |
| M28*1.50 | 26.5 | 26.676 | 26.373 | | | | |
| M28*1.0 | 27 | 27.153 | 26.917 | | | | |
| M30*3.0 | 27 | 27.252 | 26.752 | | | | |
| M30*2.0 | 28 | 28.21 | 27.835 | | | | |
| M30*1.50 | 28.5 | 28.676 | 28.376 | | | | |
| M30*1.0 | 29 | 29.153 | 28.917 | | | | |
| M32*2.0 | 30 | 30.21 | 29.835 | 附* 号螺纹自学 968 年 3 月删除 | | | |
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| 惠式螺纹（旧英制牙） | | | | 山数节距换算表 | |
|------------|-------|---------|--------|----------|---------|
| 规格 | 钻头径 | | | | |
| | A 例 | B 例 | | 山数(25.4) | 节数 |
| *W1\8-40 | 2. 65 | 2. 6 | | 100 | 0. 254 |
| *W5\32-32 | 3. 25 | 3. 2 | | 880 | 0. 3175 |
| *w3\16-24 | 3..75 | 3. 7 | | 772 | 0. 3518 |
| W1\4-20 | 5. 1 | 5 | | 64 | 0. 3969 |
| W5\16-18 | 6. 6 | 5 | | 60 | 0. 4233 |
| W3\8-16 | 8 | 6. 5 | | 56 | 0.4536 |
| W7\16-14 | 9. 4 | 7. 9 | | 48 | 0.5292 |
| W1\2-12 | 10. 7 | 9.310.5 | | 44 | 0.5773 |
| W9\16-12 | 12. 3 | 12 | | 40 | 0.635 |
| W5\8-11 | 13. 7 | 13. 5 | | 36 | 0. 7056 |
| W3\4-10 | 16. 7 | 16. 5 | | 32 | 0. 7938 |
| W7\8-9 | 19. 5 | 19. 3 | | 28 | 0. 9071 |
| W1-8 | 22. 4 | 22 | | 24 | 1. 0583 |
| W1\8-7 | 25 | 24. 8 | | 20 | 1. 27 |
| W11\4 | 28. 3 | 28 | | 18 | 1. 4111 |
| W13\8-6 | 30. 5 | 30. 3 | | 16 | 1. 5875 |
| W11\2-6 | 33. 8 | 33. 5 | | 14 | 1. 8143 |
| W15\8-5 | 36 | 35. 7 | | 13 | 1. 9538 |
| W13\4-5 | 39. 2 | 39 | | 12 | 2. 1167 |
| W11\8-5 | 41. 8 | 41. 5 | | 11 | 2. 3091 |
| W2-41\2 | 45 | 44. 7 | | 10 | 2. 54 |
| 牙套螺纹攻用 | | | | 9 | 2. 8222 |
| | | | | 8 | 3. 175 |
| 规格 | 钻头径 | 下孔径 | | 7 | 3. 6286 |
| | | 上限 | 下限 | 6 | 4. 2333 |
| M3*0.5 | 3. 1 | 3. 2 | 3. 12 | 5 | 5. 08 |
| M4*0.7 | 4. 2 | 4. 3 | 4. 17 | 41\2 | 5. 6444 |
| M5*0.8 | 5. 2 | 5. 33 | 5. 16 | 4 | 6. 35 |
| M6*1 | 6. 3 | 6. 42 | 6. 25 | 31\2 | 7. 2571 |
| M8*1.25 | 8. 4 | 8. 52 | 8. 31 | 31\2 | 7. 8154 |
| M10*1.5 | 10. 5 | 10. 62 | 10. 37 | 3 | 8. 4667 |
| M10*1.25 | 10. 4 | 10. 52 | 10. 31 | 27\8 | 8. 8348 |
| M10*1 | 10. 3 | 10. 42 | 10. 25 | 23\4 | 9. 2364 |
| M12*1.75 | 12. 5 | 12. 73 | 12. 43 | 25\8 | 9. 6762 |
| M12*1.5 | 12. 5 | 12. 62 | 12. 37 | 21\2 | 10. 16 |
| M12*1.25 | 12. 5 | 12. 52 | 12. 31 | | |
| M14*2 | 14. 5 | 14. 83 | 14.349 | | |
| M14*1.5 | 14. 5 | 14. 62 | 14. 37 | | |
| M16*2 | 16. 5 | 16. 83 | 16. 49 | | |
| M16*1.5 | 16. 5 | 16. 62 | 16. 37 | | |
| M18*2.5 | 19 | 19. 04 | 18. 58 | | |
| M18*1.5 | 18. 5 | 18. 62 | 18. 37 | | |
| M20*2.5 | 21 | 21. 04 | 20. 58 | | |
| M20*1.5 | 20. 5 | 20. 62 | 20. 37 | | |

| 美制粗螺纹 | | | | 英制管螺纹 | | | | |
|--------------------|---------|---------|----------|------------|-------|---------|---------|---------|
| 规格 UNC 外径 | 2 级牙钻孔径 | | | 规格 | 标准径 | 钻孔径 | | |
| | 标准径 | 最大 | 最小 | | | 最大 | 最小 | |
| NO. 1—64 (1. 854) | 1. 55 | 1. 582 | 1. 452 | PS1\16-28 | 6. 5 | 6. 632 | 6. 49 | |
| NO. 2-56 (2. 184) | 1. 8 | 1. 871 | 1. 695 | PS1\8-28 | 8. 5 | 8. 687 | 8. 495 | |
| NO. 3-48 (2. 515) | 2. 1 | 2. 146 | 1. 941 | Ps1\4-19 | 11. 4 | 11. 549 | 11. 341 | |
| NO. 4-40 (2. 845) | 2. 3 | 2. 385 | 2. 157 | PS3\8-19 | 15 | 15. 054 | 14. 846 | |
| NO. 5-40 (3. 173) | 2. 6 | 2. 679 | 2. 487 | PS1\2-14 | 18. 5 | 18. 733 | 18. 489 | |
| NO. 6-32 (3. 505) | 2. 8 | 2. 895 | 2. 642 | PS3\4-14 | 24 | 24. 259 | 23. 975 | |
| NO. 8-32 (4. 166) | 3. 4 | 3. 53 | 3. 302 | PS1\4-11 | 30. 2 | 30. 471 | 30. 111 | |
| NO. 10-24 (4. 826) | 3. 9 | 3. 962 | 3. 683 | PS1-1\4-11 | 38. 8 | 39. 132 | 38. 772 | |
| NO. 12-24 (5. 486) | 4. 5 | 4. 597 | 4. 344 | PS1-1\2-11 | 44. 8 | 45. 025 | 44. 665 | |
| 1\4-20 | 5. 1 | 5. 257 | 4. 979 | PS2-1\2-11 | 56. 5 | 56. 836 | 56. 476 | |
| 5\16-18 | 6. 6 | 6. 731 | 6. 401 | | | | | |
| 3\8-16 | 8 | 8. 153 | 7. 793 | 英制管螺纹 | | | | |
| 7\16-14 | 9. 4 | 9. 55 | 9. 144 | 规格 | 标准径 | | 有效牙部之长 | 标准长度之 |
| 1\2-13 | 10. 8 | 11. 023 | 10. 592 | | 使用铰刀时 | 不用铰刀时 | 度中螺牙内径 | 螺牙内径 |
| 9\16-12 | 12. 2 | 12. 446 | 11. 989 | PT1\16-28 | 6. 1 | 6. 2 | | 6. 384 |
| 5\8-11 | 13. 6 | 12. 868 | 13. 386 | PT1\8-28 | 8. 1 | 8 | | 8. 388 |
| 3\4-10 | 16. 5 | 18. 84 | 16. 307 | PT1\4-19 | 10. 7 | 11 | | 11. 174 |
| 7\8-9 | 19. 5 | 19. 761 | 19. 507 | PT3\8-19 | 14. 2 | 14. 5 | | 14. 685 |
| 1\8-8 | 22. 2 | 22. 606 | 21. 971 | PT1\2-14 | 17. 6 | 13 | | 18. 263 |
| 1-1\8-7 | 25 | 25. 349 | 24. 6398 | PT3\4-14 | 23 | 23. 5 | | 23. 663 |
| 1-1\4-7 | 28. 2 | 28. 524 | 27. 813 | PT1\4-11 | 29 | 29. 5 | | 29. 822 |
| 1-3\8-6 | 30. 8 | 31. 115 | 30. 353 | PT1-1\4-11 | 37. 5 | 38 | | 38. 339 |
| 1-1\2-6 | 34 | 34. 29 | 33. 528 | PT1-1\2-11 | 43. 4 | 44 | | 44. 232 |
| 1-3\4-5 | 39. 5 | 39. 827 | 38. 964 | PT2-2-11 | 54. 9 | 55. 5 | | 55. 844 |
| 1-4-1\2 | 45. 2 | 45. 593 | 44. 679 | | | | | |
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| 美制管螺纹 | | | | 管用螺纹(PT) | | | | |
|------------|--------------|-----------------|--------------|-----------|---------|-----------|---------------|----|
| 规格 | 钻头径()内英制尺寸 | | | 规格 | 钻头径 | | 有效螺纹长度用 内径 | 标用 |
| | NPT | | NPSC | | 铰刀 时 | 不用铰 刀时 | | |
| | 使用铰刀时 | 不使用铰刀时 | | | | | | |
| | 5.94(0.23) | 6.15(0.242) | 6.35(0.250) | PT1\16-28 | 6. 1 | 6. 2 | 6. 244 | 6 |
| . | 5.94(0.23) | 6.15(0.242) | 6.35(0.250) | PT1\8-28 | 8. 1 | 8. 2 | 8. 249 | 8 |
| 1\8-27 | 8.33(0.328) | 8. 43 (0. 332) | 8.74(0.344) | PT1\4-19 | 10. 7 | 11 | 10. 926 | 11 |
| 1\4-18 | 10.72(0.422) | 11. 13 (0. 438) | 11.13(0.438) | PT3\8-19 | 14. 2 | 14. 5 | 14. 448 | 14 |
| 3\8-18 | 14.27(0.526) | 14. 27 (0. 562) | 14.68(0.578) | PT1\2-14 | 17. 6 | 18 | 17. 979 | 18 |
| 1\2-14 | 17.48(0.688) | 17. 86 (0. 703) | 18.26(0.719) | PT3\4-14 | 23 | 23. 5 | 23. 378 | 23 |
| 3\4-14 | 22.63(0.891) | 23. 0 (0. 906) | 23.42(0.922) | PT1-11 | 29 | 29. 5 | 29. 459 | 29 |
| 1--111\2 | 28.58(1.125) | 28. 98 (1. 414) | 29.36(1.156) | PT11\4-11 | 37 | 38 | 37. 976 | 38 |
| 11\4-111\2 | 37.31(1.469) | 37. 69 (1. 484) | 38.1(1.5) | PT11\2-11 | 43 | 44 | 43. 869 | 42 |
| 11\2-111\2 | 43.26(1.703) | 43. 66 (1. 719) | 44.45(1.750) | PT2-11 | 54 | 55. 5 | 55. 412 | 55 |
| 2-111\2 | 55.17(2.172) | 55. 58 (2. 188) | 56.36(2.219) | 管用螺纹(PF) | | | | |
| 21\2-8 | 65.48(2.578) | 66. 27 (2. 609) | 67.46(2.656) | 规格 | 钻头 径 | AB 级螺纹内径 | | |
| 乾封美制管螺纹 | | | 上限 | | | 下限 | | |
| 规格 | 钻头径()内英制尺寸 | | | PF1\16-28 | 6. 7 | 6. 843 | 6.561 | |
| | NPTF | | NPSF | PF1\8-28 | 8. 7 | 8. 848 | 8. 566 | |
| | 使用铰刀时 | 不使用铰刀时 | | PF1\4-19 | 11. 7 | 11. 89 | 11. 445 | |
| 1\16-27 | 5.94(0.234) | 6.15(0.242) | 6.25(0.246) | PF3\8-19 | 15. 2 | 15.395 | 14. 95 | |
| 1\8-27 | 8.33(0.328) | 8.43(0.322) | 8.61(0.339) | PF1\2-14 | 19 | 19. 172 | 18. 631 | |
| 1\4-18 | 10.72(0.422) | 11.13(0.438) | 11.13(0.438) | PF5\8-14 | 21 | 21. 128 | 20. 587 | |
| 3\8-18 | 14.27(0.562) | 14.27(0.526) | 14.68(0.578) | PF3\4-14 | 24. 5 | 24. 658 | 24. 117 | |
| 1\2-14 | 17.48(0.688) | 17.86(0.703) | 17.86(0.703) | PF7\8-14 | 28. 2 | 28. 418 | 27. 887 | |
| 3\4-14 | 22.63(0.891) | 23.01(0.906) | 23.42(0.922) | PF1--11 | 30. 5 | 30. 931 | 30. 291 | |
| 1-111\2 | 28.58(1.125) | 28.98(1.141) | 29.36(1.156) | PF11\8-11 | 35. 2 | 35. 579 | 34.93.9 | |
| 11\4-111\2 | 37.31(1.469) | 37.69(1.484) | | PF11\4-11 | 39. 2 | 39. 592 | 38. 952 | |
| 11\2-111\2 | 43.26(1.703) | 43.66(1.719) | | PF11\2-11 | 45 | 45. 458 | 44. 845 | |
| 2-111\2 | 55.17(2.172) | 55.58(2.188) | | PF13\4-11 | 51 | 51. 428 | 50. 788 | |
| 21\2-8 | 65.48(2.578) | 66.27(2.609) | | PF2-11 | 57 | 57. 296 | 56. 656 | |
| | | | | 管用螺纹(PS) | | | | |
| | | | | 规格 | 钻头 径 | 螺纹内径 | | |
| | | | | | | 上限 | 下限 | |
| | | | | PS1\16-28 | 6. 5 | 6. 632 | 6. 4 | |
| | | | | PS1\8-28 | 8. 5 | 8. 637 | 8. 4 | |
| | | | | PS1\4-19 | 11. 4 | 11. 549 | 11. 3 | |
| | | | | PS3\8-19 | 15 | 15. 054 | 14. 8 | |
| | | | | PS1\2-14 | 18. 5 | 18. 773 | 18. 4 | |
| | | | | PS3\4-14 | 24 | 24. 259 | 23. 9 | |
| | | | | PS1--11 | 30. 2 | 30. 471 | 30. 1 | |
| | | | | PS11\4-11 | 38. 8 | 39. 132 | 38. 7 | |
| | | | | PS11\2-11 | 44. 8 | 45. 025 | 44. 6 | |
| | | | | PS--11 | 56. 5 | 56. 863 | 56. 4 | |
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| 美制迫牙丝攻钻孔径 | | | | 英制螺纹 | | |
|------------|-------|-------|-------|----------|--------------|------|
| 规格 | 精度等级 | | | 规格 | 钻孔径 | |
| | G4—G6 | G7—G8 | G9 | | 硬材 | 软材 |
| NO.2-56UNC | 1.94 | | | W1\8-40 | 2.65 | 2.5 |
| NO.3-48 | 2.23 | | | W5\32-32 | 3.25 | 3.2 |
| NO.4-40 | 2.5 | | | W3\16-24 | 3.75 | 3.7 |
| NO.6-32 | 2.83 | | | W1\4-20 | 5.1 | 5 |
| NO.8-32 | 3.07 | 3.75 | | W5\16-16 | 6.6 | 6.5 |
| NO.10-24 | 3.78 | 4.3 | | W3\8-18 | 8 | 7.9 |
| NO.12-24 | 4.24 | 4.56 | | W7\16-14 | 9.4 | 9.3 |
| 1\4-20 | 4.9 | 5.72 | | W1\2-12 | 10.7 | 10.5 |
| 5\16-18 | | 7.24 | | W9\16-12 | 12.3 | 12 |
| 3\8-16 | | 8.74 | 8.81 | W5\8-11 | 13.7 | 13.5 |
| 7\16-14 | | 10.2 | 10.3 | W3\4-10 | 16.7 | 16.5 |
| 1\2-13 | | 11.27 | 11.82 | W7\8-9 | 19.5 | 19.3 |
| NO.2-64UNF | 1.97 | | | W1\8-8 | 22.4 | 22 |
| NO.3-56 | 2.27 | | | W1-1\8-7 | 25 | 24.8 |
| NO.4-48 | 2.56 | | | W1-1\4-7 | 28.3 | 28 |
| NO.5-44 | 2.86 | | | | | |
| NO.6-40 | 3.16 | | | 针车用螺纹 | | |
| NO.8-36 | 3.78 | | | 规格 | 滚造径 | |
| NO.10-32 | 4.39 | 4.43 | | SW1\8-40 | 2.735--2.688 | |
| NO.12-28 | 4.99 | 5.04 | | SM1\8-44 | 2.769--2.722 | |
| 1\4-28 | 5.85 | 5.9 | | | | |
| 5\16-24 | 7.36 | 7.41 | | | | |
| 3\8-24 | | 9 | | | | |
| 7\16-20 | | 10.48 | 10.54 | | | |
| 1\2-20 | | 12.07 | 12.13 | | | |

| 美制特制螺纹 | | | | 针车螺纹 | |
|--------------|---------|---------|---------|------------|---------------|
| 规格（UNEF） | 标准径 | 2 级牙钻孔径 | | 规格 | 滚造径 |
| | | 最大 | 最小 | SM1\8-40 | 2.735-2.668 |
| NO.12-32 | 4. 7 | 4. 826 | 4. 623 | SM1\8-44 | 2.769-2.722 |
| | | | | SM9\64-40 | 3.128-3.083 |
| 1\4-32 | 5. 6 | 5. 69 | 5. 486 | SM11\64 | 3.855-3.805 |
| 5\16-32 | 7. 1 | 7. 264 | 7. 087 | SM3\16-32 | 4.205-4.155 |
| 3\8-32 | 8. 7 | 8. 865 | 8. 661 | SM3\16-28 | 4.143-4.093 |
| 7\16-28 | 10. 2 | 10. 338 | 10. 135 | SM7\32-32 | 5.003-4.955 |
| 1\2-28 | 11. 6 | 13. 386 | 11. 709 | SM15\64-28 | 5.325-5.570 |
| 9\16-24 | 13. 2 | 14. 986 | 13. 132 | SM1\4-40 | 5.890-54.735 |
| 5\8-24 | 14. 8 | 14. 986 | 14. 732 | SM1\4-28 | 5.721-5.368 |
| 3\4-20 | 17. 8 | 17. 958 | 17. 678 | SM9\32-28 | 6.508-6.648 |
| 7\8-20 | 21 | 21. 133 | 20. 859 | SM11\31-28 | 8.092-8.432 |
| 1--20 | 24 | 24. 308 | 24. 028 | SM3\8-28 | 8.880-8.015 |
| | | | | SM7\16-28 | 10.466-10.401 |
| 美制管螺纹 | | | | SM7\16-16 | 10.037-9.967 |
| | | | | SM1\2-20 | 11.819-11.749 |
| | | | | SM9\16-20 | 13.4-13.425 |
| 规格 | 钻孔径 | | NPS | 公制螺纹 | |
| | NPT | | | | |
| | 最大 | 最小 | | | |
| 1\16-27 | 6. 1 | 6. 25 | 6. 35 | 规格 | 滚造径 |
| 1\8-27 | 8. 38 | 8. 43 | 8. 74 | M3*0.5 | 2.63-2.5 |
| 1\4-18 | 10. 72 | 11. 13 | 11. 13 | M3*0.6 | 2.53-2.5 |
| 3\8-18 | 14. 27 | 14. 27 | 14. 68 | M3.5*0.6 | 3.06-3.03 |
| 1\2-14 | 17. 48 | 17. 86 | 18. 26 | M4*0.7 | 3.49-3.15 |
| 3\4-14 | 22. 63 | 23. 01 | 23. 42 | M4*0.75 | 3.45-3.41 |
| 1-11-1\2 | 28. 58 | 28. 98 | 29. 36 | M4.5*0.75 | 3.96-3.92 |
| 1-1\4-11-1\2 | 37. 31 | 37. 69 | 38. 1 | M5*0.8 | 4.43-4.38 |
| 1-1\2-11-1\2 | 43. 66 | 44. 04 | 44. 45 | M5*0.9 | 4.36-4.31 |
| 2-11-1\2 | 55. 58 | 55. 96 | 56. 36 | M6*1.0 | 5.3-5.25 |
| 英制电器螺纹 | | | | M7*1.0 | 6.3-6.25 |
| | | | | M8*1.0 | 7.28-7.23 |
| | | | | M8*1.25 | 7.12-7.07 |
| 规格 | 钻孔径 | | | | |
| 2BA | 4-4.2 | | | | |
| 3BA | | | | | |
| 4BA | 3-3.2 | | | | |
| 5BA | 2.7-2.8 | | | | |
| 6BA | 2.4-2.5 | | | | |
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| 美制细螺纹 | | | | 公制迫牙丝攻钻孔径 | | | |
|-----------------|-------|---------|---------|-----------|--------|--------|--------|
| 规格(丝牙外径) | 标准径 | 最大 | 最小 | 规格 | 精度等级 | | |
| 7—G8 | 1. 25 | 1. 305 | 1. 182 | | G4—G6 | G7—G8 | G9 |
| NO.1-72(1.854) | 1. 55 | 1. 612 | 1. 474 | M1.0*0.25 | 0. 86 | 0. 88 | |
| NO.2-64(2.134) | 1. 85 | 1. 912 | 1. 756 | M1.1*0.25 | 0. 96 | 0. 98 | |
| NO.3-56(2.515) | 2. 1 | 2. 197 | 2. 025 | M1.2*0.25 | 1. 06 | 1. 08 | |
| NO.4-48(2.345) | 2. 4 | 2. 456 | 2. 271 | M1.4*0.3 | 1. 24 | 1. 25 | |
| NO.5-44(3.175) | 2. 7 | 2. 74 | 2. 551 | M1.6*0.35 | 1. 41 | 1. 43 | |
| NO.6-40(3.505) | 2. 9 | 3. 022 | 2. 82 | M1.7*0.35 | 1. 51 | 1. 53 | |
| NO.8-36(4.166) | 3. 5 | 3. 606 | 3. 404 | M1.8*0.35 | 1. 61 | 1. 63 | |
| NO.10-32(4.326) | 4. 1 | 4. 165 | 3. 963 | M2.0*0.4 | 1. 78 | 1. 8 | |
| NO.12-28(5.846) | 4. 6 | 4. 724 | 4. 496 | M2.2*0.45 | 1. 95 | 1. 98 | |
| 1\4-28 | 5. 5 | 5. 588 | 5. 36 | M2.3*0.4 | 2. 08 | 2. 1 | |
| 5\16-24 | 6. 9 | 7. 035 | 6. 782 | M2.5*0.45 | 2. 25 | 2. 28 | |
| 3\8-24 | 8. 5 | 8. 636 | 8. 382 | M2.6*0.45 | 2. 35 | 2. 38 | |
| 7\16-20 | 9. 9 | 10. 033 | 9. 729 | M3.0*0.5 | 2. 73 | 2. 75 | |
| 1\2-20 | 11. 5 | 11. 607 | 11. 329 | M3.5*0.6 | 3. 17 | 3. 2 | |
| 9\16-18 | 12. 9 | 13. 081 | 12. 751 | M4.0*0.7 | 3. 62 | 3. 65 | 3. 69 |
| 5\8-18 | 14. 5 | 14. 681 | 14. 351 | M5.0*0.8 | 4. 56 | 4. 6 | 4. 64 |
| 3\4-16 | 17. 5 | 17. 678 | 17. 323 | M6.0*1.0 | 5. 45 | 5. 5 | 5. 55 |
| 7\8-14 | 20. 5 | 20. 675 | 20. 27 | M7.0*1.0 | 6. 45 | 6. 5 | 6. 55 |
| 1\8-12 | 23. 2 | 23. 571 | 23. 114 | M8.0*1.25 | 7. 31 | 7. 38 | 7. 44 |
| 1-1\8-12 | 26. 5 | 26. 746 | 26. 289 | M10*1.5 | 9. 18 | 9. 25 | 9. 32 |
| 1-1\4-12 | 29. 5 | 29. 921 | 29. 464 | M10*1.25 | 9. 31 | 9. 38 | 9. 44 |
| 1-3\8-12 | 32 | 33. 096 | 32. 639 | M12*1.75 | 11. 04 | 11. 12 | 11. 21 |
| 1-1\2-12 | 36 | 36. 271 | 35. 814 | M12*1.25 | 11. 31 | 11. 38 | 11. 44 |
| | | | | | | | |
| | | | | | | | |

| 英美联合螺纹 | | | | 英美联细螺纹 | | | |
|-------------|-------|---------|---------|-------------|-------|---------|---------|
| 规格 | 钻头径 | 2B 螺纹径 | | 规格 | 钻头径 | 下孔径 | |
| | | 上限 | 下限 | | | 上限 | 下限 |
| NO.1-64UNC | 1. 55 | 1.582 | 1. 425 | no.0-80unf | 1. 25 | 1. 305 | 1. 182 |
| NO.2-56UNC | 1. 8 | 1. 871 | 1. 695 | no.1-72unf | 1. 55 | 1. 612 | 1. 474 |
| NO.3-48UNC | 2. 1 | 2. 146 | 1. 941 | no.2-64-unf | 1. 85 | 1. 912 | 1. 756 |
| NO.4-40UNC | 2. 3 | 2. 385 | 2. 157 | no.3-565unf | 2. 1 | 2. 197 | 2. 025 |
| NO.5-40UNC | 2. 6 | 2. 679 | 2. 487 | no.4-48unf | 2. 4 | 2. 458 | 2. 271 |
| NO.6-32UNC | 2. 8 | 2. 895 | 2. 642 | no.5-44unf | 2. 7 | 2. 74 | 2. 551 |
| NO.832UNC | 3. 4 | 3. 53 | 3. 302 | no.6-40unf | 2. 9 | 3. 022 | 2. 82 |
| NO.10-24UNC | 3. 9 | 3. 926 | 3. 683 | no.8-36unf | 3. 5 | 3. 606 | 3. 404 |
| NO.12-24UNC | 4. 5 | 4. 597 | 4. 344 | no.10-32unf | 4. 1 | 4. 165 | 3. 963 |
| 1\4-20UNC | 5. 1 | 5. 257 | 4..979 | no.12-28unf | 4. 6 | 4. 724 | 4. 496 |
| 5\16-18unc | 6. 6 | 6. 731 | 6. 401 | 1\4-28unf | 5. 5 | 5. 588 | 5. 36 |
| 3\8-16UNC | 8 | 8. 153 | 7. 798 | 5\16-24unf | 6. 9 | 7. 035 | 6. 782 |
| 7\16-14UNC | 9. 4 | 9. 55 | 9. 144 | 3\8-24unf | 8. 5 | 8. 636 | 8. 382 |
| 1\2-13UNC | 10. 8 | 11. 023 | 10. 599 | 7\16-20unf | 9. 9 | 10. 033 | 9. 729 |
| 9\16-12UNC | 12. 2 | 12. 446 | 11. 989 | 1\2-unf | 11. 5 | 11. 607 | 11. 329 |
| 5\8-11UNC | 13. 6 | 13. 868 | 13. 386 | 9\16-unf | 12. 9 | 13. 081 | 12. 75 |
| 3\4-10UNC | 16. 5 | 16. 84 | 16. 307 | 5\8-18unf | 14. 5 | 14. 681 | 14. 35 |
| 7\8-9UNC | 19. 5 | 19. 761 | 19. 177 | 3\4-16unf | 17. 5 | 17. 678 | 17. 32 |
| 1--8UNC | 22. 2 | 22. 606 | 21. 971 | 7\8-14unf | 20. 5 | 20. 675 | 20. 27 |
| 11\8-7UNC | 25 | 25. 349 | 24. 813 | 1--12unf | 23. 2 | 23. 571 | 23. 11 |
| 11\4-7UNC | 28. 2 | 28. 524 | 27. 813 | 11\8-12unf | 26. 5 | 26. 746 | 26. 28 |
| 13\8-6UNC | 30. 8 | 31. 115 | 30. 353 | 11\4-12unf | 29. 5 | 29. 921 | 29. 46 |
| 11\2-6UNC | 34 | 34. 29 | 33. 528 | 13\8-12unf | 32. 8 | 33. 096 | 32. 63 |
| 13\4-5UNC | 39. 5 | 39. 827 | 38. 964 | 11\2-12unf | 36 | 36. 271 | 35. 81 |
| 2-41\2UNC | 45. 2 | 45. 593 | 44. 679 | | | | |
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| 公制粗螺纹 | | | | 公制细螺纹 | | | | | | | |
|-----------|------|--------|-------|-----------|------|--------|-------|---------|------|--------|--------|
| 规格 | 标准径 | 最大 | 最小 | 规格 | 标准径 | 最大 | 最小 | 规格 | 标准径 | 最大 | 最小 |
| M1.0*0.25 | 0.75 | 0.785 | 0.729 | M1.0*0.2 | 0.8 | 0.821 | 0.783 | M15*1.0 | 14 | 14.353 | 13.917 |
| M1.1*0.25 | 0.85 | 0.885 | 0.829 | M1.1*0.2 | 0.9 | 0.921 | 0.883 | M16*1.5 | 14.5 | 14.676 | 14.376 |
| M1.2*0.25 | 0.95 | 0.985 | 0.929 | M1.2*0.2 | 1 | 1.021 | 0.983 | M16*1.0 | 15 | 15.153 | 14.917 |
| M1.4*0.3 | 1.1 | 1.142 | 1.075 | M1.4*0.2 | 1.2 | 1.221 | 1.183 | M17*1.5 | 15.5 | 15.676 | 15.376 |
| M1.6*0.35 | 1.25 | 1.321 | 1.221 | M1.6*0.2 | 1.4 | 1.421 | 1.383 | M17*1.0 | 16 | 16.153 | 15.917 |
| M1.7*0.35 | 1.35 | 1.421 | 1.321 | M1.7*0.2 | 1.45 | 1.5 | 1.46 | M18*2.0 | 16 | 16.21 | 15.835 |
| M1.8*0.35 | 1.45 | 1.521 | 1.421 | M1.8*0.2 | 1.6 | 1.621 | 1.583 | M18*1.5 | 16.5 | 16.676 | 16.376 |
| M2.0*0.4 | 1.6 | 1.679 | 1.567 | M2.0*0.25 | 1.75 | 1.785 | 1.729 | M18*1.0 | 17 | 17.153 | 16.917 |
| M2.2*0.45 | 1.75 | 1.888 | 1.713 | M2.2*0.25 | 1.95 | 1.985 | 1.929 | M20*2.0 | 18 | 18.21 | 17.835 |
| M2.3*0.4 | 1.9 | 1.979 | 1.867 | M2.3*0.25 | 2.05 | 2.061 | 2.001 | M20*1.5 | 18.5 | 18.676 | 18.376 |
| M2.5*0.45 | 2.1 | 2.138 | 2.013 | M2.5*0.35 | 2.2 | 2.221 | 2.121 | M20*1.0 | 19 | 19.153 | 18.917 |
| M2.6*0.45 | 2.2 | 2.238 | 2.113 | M2.5*0.35 | 2.2 | 2.246 | 2.186 | M22*2.0 | 20 | 20.21 | 19.835 |
| M3.0*0.5 | 2.5 | 2.599 | 2.459 | M3.0*0.35 | 2.7 | 2.721 | 2.621 | M22*1.5 | 20.5 | 20.676 | 20.376 |
| M3.0*0.6 | 2.4 | 2.44 | 2.28 | M3.5*0.35 | 3.2 | 3.221 | 3.121 | 22*1.0 | 21 | 21.153 | 20.917 |
| M3.5*0.6 | 2.9 | 3.01 | 2.85 | M4.0*0.5 | 3.5 | 3.599 | 3.459 | M24*2.0 | 22 | 22.21 | 21.835 |
| M4.0*0.7 | 3.8 | 3.422 | 3.242 | M4.5*0.5 | 4 | 4.099 | 3.959 | M24*1.5 | 22.5 | 22.676 | 22.376 |
| M4.0*0.75 | 3.25 | 3.326 | 3.106 | M5.0*0.5 | 4.5 | 4.599 | 4.459 | M24*1.0 | 23 | 23.153 | 22.917 |
| M4.5*0.7 | 3.8 | 3.878 | 3.688 | M5.5*0.5 | 5 | 5.099 | 4.959 | M25*2.0 | 23 | 23.21 | 22.835 |
| M5*0.8 | 4.2 | 4.334 | 4.134 | M6.0*0.75 | 5.3 | 5.378 | 5.188 | M25*1.5 | 23.5 | 23.676 | 23.376 |
| M5*0.9 | 4.1 | 4.17 | 3.98 | M6.0*0.5 | 5.5 | 5.55 | 5.4 | M25*1.0 | 24 | 24.153 | 23.917 |
| M6*1.0 | 5 | 5.153 | 4.917 | M7.0*0.75 | 6.3 | 6.378 | 6.188 | M26*1.5 | 24.5 | 24.676 | 24.876 |
| M7*1.0 | 6 | 6.153 | 5.917 | M7.0*0.5 | 6.5 | 6.55 | 6.4 | M27*2.0 | 25 | 25.21 | 24.735 |
| M8*1.25 | 6.8 | 6.912 | 6.647 | M8.0*1 | 7 | 7.153 | 6.917 | M27*1.5 | 25.5 | 25.676 | 25.376 |
| M9*1.25 | 7.8 | 7.912 | 7.647 | M8.0*0.75 | 7.3 | 7.378 | 7.188 | M27*1.0 | 26 | 26.153 | 25.735 |
| M10*1.5 | 8.5 | 8.676 | 8.376 | M8.0*0.5 | 7.5 | 7.52 | 7.4 | M28*2.0 | 26 | 26.21 | 25.835 |
| M11*1.5 | 9.5 | 9.676 | 9.376 | M9.0*1 | 8 | 8.153 | 7.917 | M28*1.5 | 26 | 26.676 | 26.376 |
| M12*1.75 | 10.3 | 10.24 | 10.11 | M9.0*0.75 | 8.3 | 8.378 | 8.188 | M28*1.0 | 27 | 27.153 | 26.917 |
| M14*2.0 | 12 | 12.21 | 11.84 | M10*1.25 | 8.8 | 8.912 | 8.647 | M30*3.0 | 27 | 27.252 | 26.752 |
| M16*2.0 | 14 | 14.21 | 13.84 | M10*1.0 | 9 | 9.153 | 8.917 | M30*2.0 | 28 | 28.21 | 27.835 |
| M18*2.5 | 15 | 15.144 | 15.29 | M10*0.75 | 9.3 | 9.378 | 9.188 | M30*1.0 | 28 | 28.676 | 28.376 |
| M20*2.5 | 17 | 17.744 | 17.29 | M10*0.5 | 9.5 | 9.52 | 9.4 | M32*2.0 | 30 | 29.153 | 28.917 |
| M22*2.5 | 19 | 19.744 | 19.29 | M11*1.0 | 10 | 10.153 | 9.917 | M32*1.5 | 30 | 30.21 | 29.835 |
| M24*3.0 | 21 | 21.252 | 20.75 | M11*0.75 | 10.3 | 10.378 | 10.19 | M33*3.0 | 30 | 30.676 | 30.376 |
| M27*3.0 | 24 | 24.252 | 23.75 | M12*1.5 | 10.5 | 10.676 | 10.38 | M33*2.0 | 31 | 30.252 | 29.752 |
| M30*3.5 | 26.5 | 26.771 | 26.21 | M12*1.25 | 10.8 | 10.912 | 10.65 | M33*1.5 | 31.5 | 31.21 | 30.835 |
| | | | | M12*1 | 11 | 11.153 | 10.92 | M35*1.5 | 33.5 | 33.676 | 31.376 |
| | | | | M12*0.5 | 11.5 | 11.523 | 11.4 | M36*3.0 | 33 | 33.252 | 32.752 |
| | | | | M14*0.5 | 12.5 | 12.676 | 12.38 | M36*2.0 | 34 | 34.21 | 33.835 |
| | | | | M14*1.0 | 13 | 13.153 | 12.92 | M36*1.5 | 34 | 34.676 | 34.376 |
| | | | | M15*1.50 | 13.5 | 13.676 | 13.38 | | | | |
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